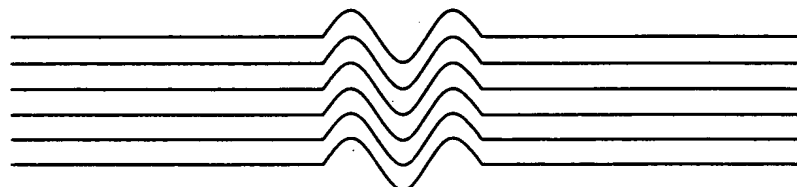
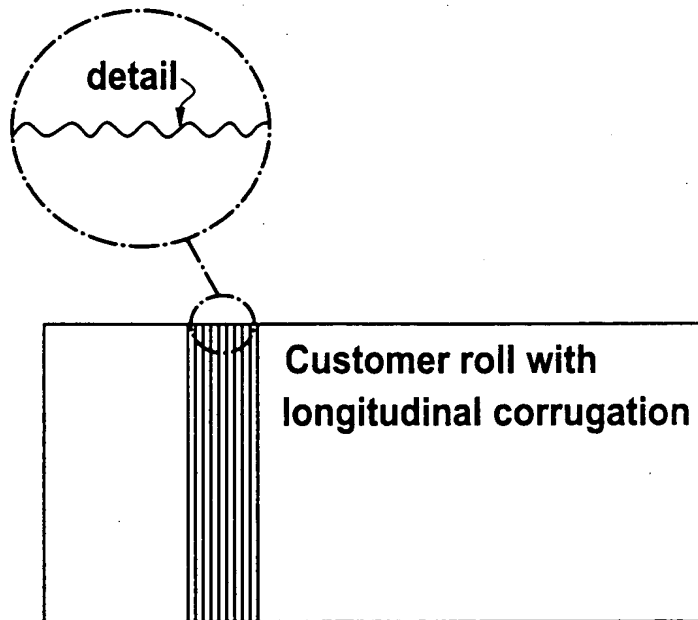
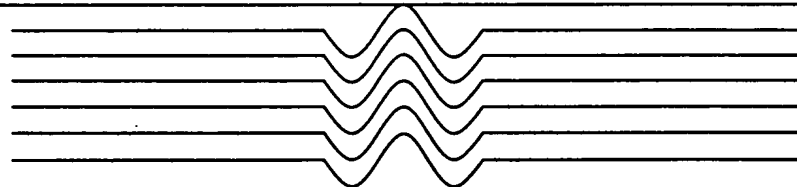
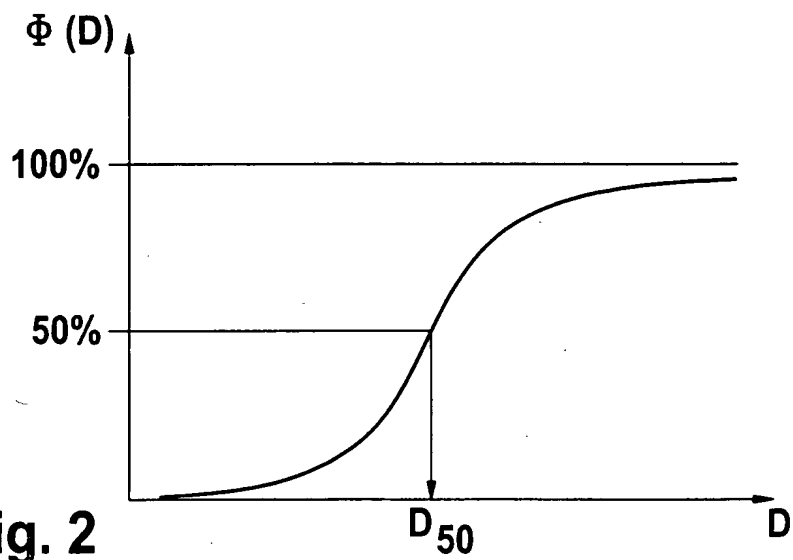


**Fig. 1**

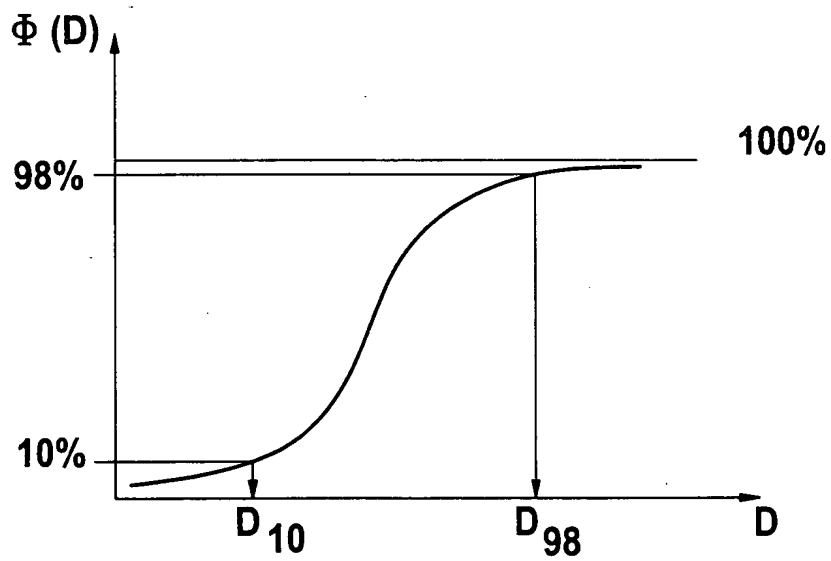


**Customer roll with longitudinal corrugation**





**Fig. 2**



**Fig. 3**